

Work Order ID 65841

Wednesday, April 13, 2011 10:59:36 AM



Page 1

Item ID:	D3562-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, RH					
Start Date:	1/26/2011	Start Qty:	3.00	Cust Item ID:		
Required Date:	4/29/2011	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	Rev E								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding								

PL 11.04.14 3

110	QC- Inspect part completeness to step on W/O	0.00							
	QC								
QC	Memo	0.00							
Quality Control									

PL 11.04.14 3 **PTO →**

120	Chemical Conversion Coat per.QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							

PL 11.04.14 3

W/O: 65841		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
14.04.14	110	Change To Qc6	<i>[Signature]</i>	11.04.28			<i>[Signature]</i> 11.04.14

Part No: D 3562-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>3</u>			
			SAD 11-04-16						
140 Small Fab Small Fab	Small Fab Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <u>m114158</u>	0.00 0.00				<u>3</u>	<u>0</u>		
			11-04-16						
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>73</u>			
			5 w/11/16			<u>24</u>			

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00				3	0		
	1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>M114703</u> 2-Grind end cap welds flush as per Dwg D3562								
170 QC	QC5 Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							Pro →
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							(x3 PH)

W/O: 65841		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/4/21	#170	change to QCI inspection	<i>[Signature]</i>	11.04.21			<i>[Signature]</i>

Part No: D3562-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Accept



Setup Start



Stop



Start Date: 1/26/2011 Start Qty: 3.00
Required Date: 4/29/2011 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3		BL 11-4-25.	
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M116 964. Memo START TIME: 2:35 OVEN TEMPERATURE: 320 FINISH TIME: 3:05.	0.00 0.00				3		BL 11-4-25.	
210 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M117365 Memo	0.00 0.00				3		all unload 26 RH	

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Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 1/26/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

EFS 11/04/29 (3)

230 Identify as per dwg & Stock Location: G-A 0.00

Packaging Memo 0.00

Packaging

w/o
68433

EFS 11/04/29 (3)

240 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/04/28 JF

MF
11-04-28

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Picklist Print

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Work Order ID: 65841

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 1/26/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN-987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC*

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C		Manufactured	No			100	Each	149.0000	1	3			
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	20	
64409	20	
WA	129	
46910	2	
64409	1	
66970	126	

D2734		Manufactured	No			140	Each	73.0000	2	6			
Step End Plate													

Location	Loc Qty	Loc Code
WA015	73	
66143	73	

D3560-042		Manufactured	No			140	Each	6.0000	1	3			
Arm Weldment													

Location	Loc Qty	Loc Code
WA013	6	
48386	6	

Handwritten notes:
 11.04.15
 11.04.22
 11.04.15
 23

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 1/26/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

D3560-044

Manufactured

No

140

Each

7.0000

1

3



Arm Weldment



11.04.15

Location

Loc Qty

Loc Code

WA013

7

48388

7

3

MS20600-AD4W5

Purchased

No

160

Each

535.0000

32

96



Blind Rivet



11.04.28

Location

Loc Qty

Loc Code

ST321

379

114382

279

116289

100

42

WA018

156

111477

156

54

W/O:		WORK ORDER CHANGES					
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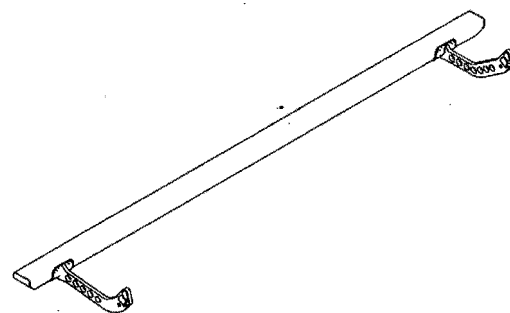
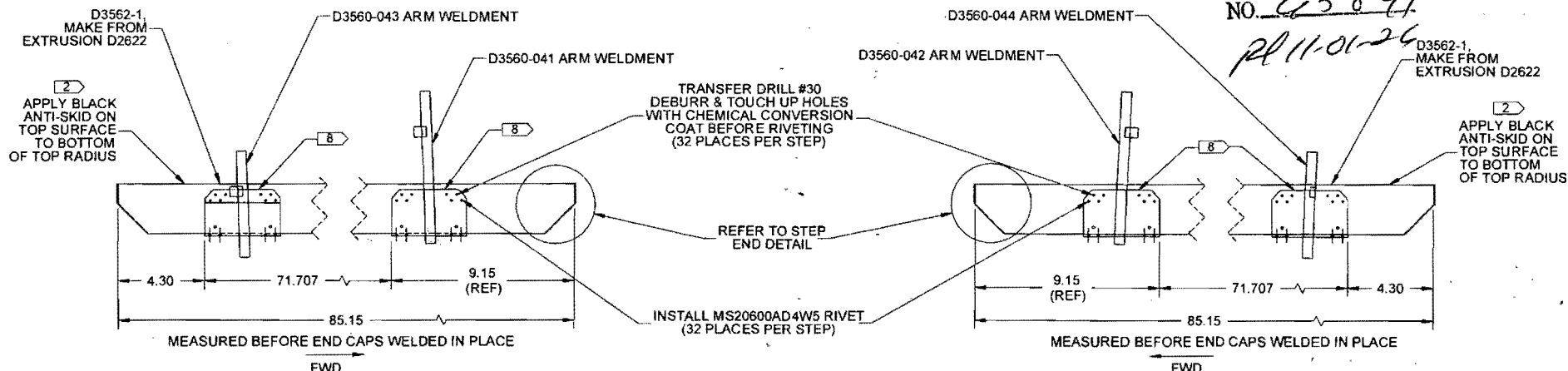
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NO. 65841

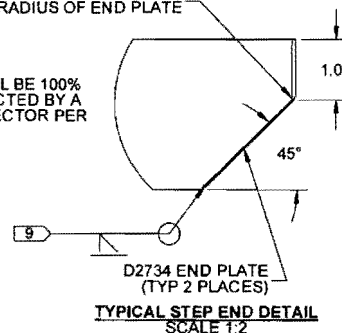
PL11-01-26



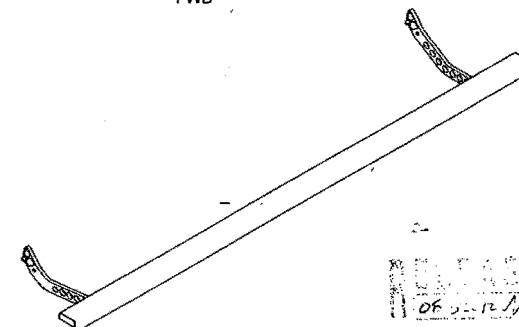
D3562-041 LH STEP ASSEMBLY

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
SCALE 1:2



D3562-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
1	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

# E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	9P		
DRAWN	SE		
CHECKED	LE		
MFG. APPR.	M		
APPROVED	100		
DE APPR.	100		
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E
SHEET 1 OF 1
TITLE **STEP ASSEMBLY** SCALE 1:5

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